

Date: Tuesday, 11/29/2005 7:09:41 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 25059		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D3389 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>Est. A. 05.08.31</u>	Due Date	: 12/9/2005
Checked & Approved By	: <u>New Issue KS/JLM</u>	Qty:	5 Um: Each
Comment	: Created By Auto Work Order		

Additional Product:

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D25003100 Ext'n -1' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty Part Number
1 D2500-3-100Description Batch
Web Extrusion

Batch

B21570 PM 05-12-13

Tools:

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3389

Drill pilot holes using DT8785 as per Dwg D3389

Open holes to finish size as per Dwg D3389

Deburr

} PM 05-12-13

Tools:

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Tools:

BE 05-12-14

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A m 05-12-14

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 412 WEB

Job Number: 25059 Part Number: D33891

Job Number: 



Seq. #: Machine Or Operation: Description :
5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION DP 05-12-14

Tools:

6.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG A.M 05-12-14

Tools:

7.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL Inspection Level 21 SUC 05/12/14 (5) 05/12/15 (5)

Tools:

Job Completion 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

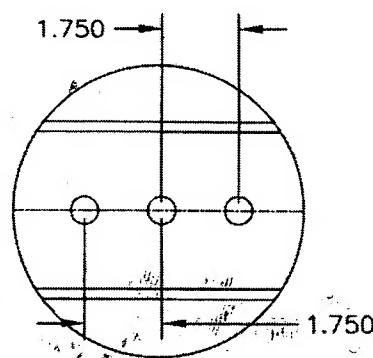
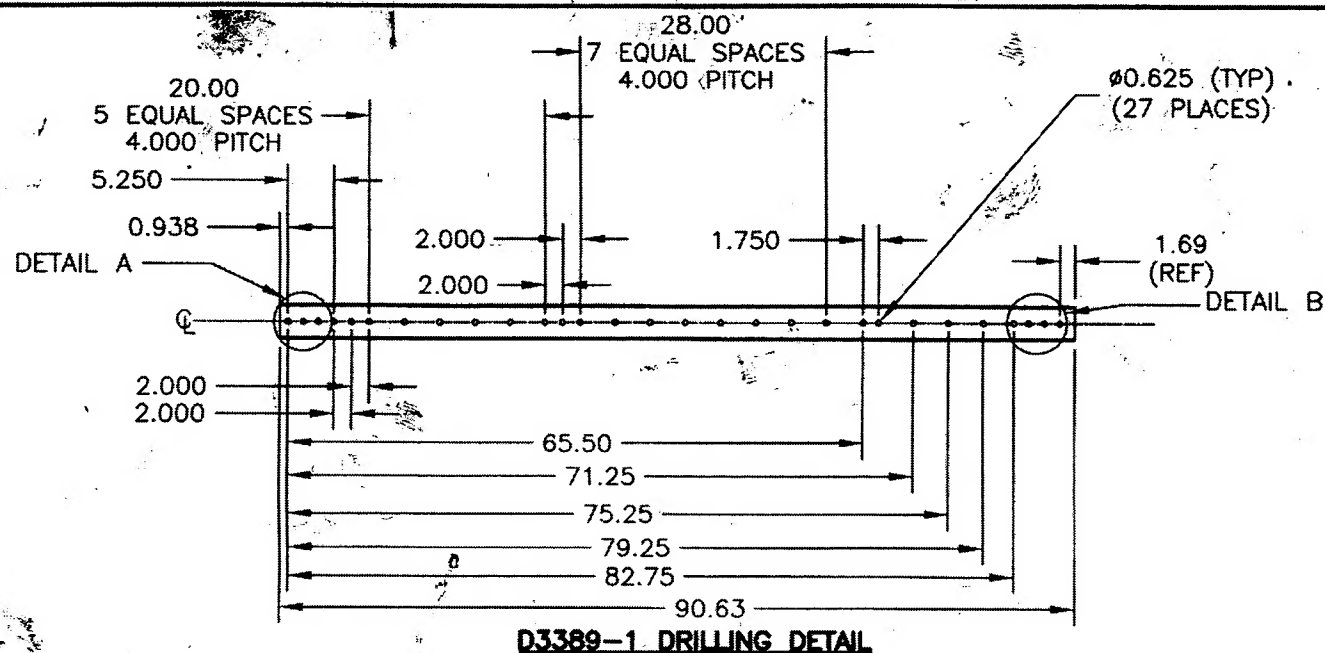
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

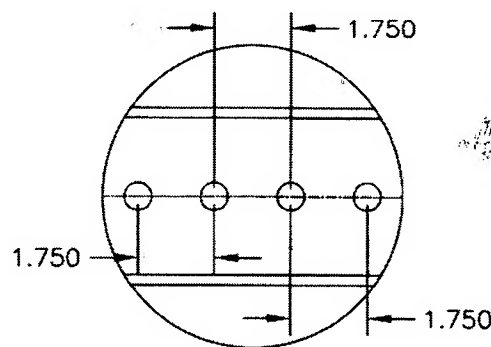
NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN PH		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3389		REV. B	
DATE 05.06.13	TITLE 412 WEB		SHEET 1 OF 1		
A	05.02.07		SCALE 1:20		
B	05.06.13		UPDATE DIMENSIONING		



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05-08-09

Copyright © 2005 by DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

